

Work Order ID 83947

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83947

Page 1

Item ID: D3270-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Scupper Assembly
 Start Date: 27/04/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3270	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Cut D3270-3 as per Dwg D3270								
110		0.00							
110	Weld per dwg A/R Aluminum rod Batch: <u>1119745</u>	0.00							
Large Fab	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld D3270-3 to D3270-1 as per Dwg D3270 using welding Jig D3270-041T1 and QSI 004.								
120		0.00							
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

Q 12-5-2

Q 12-5-2

6 Q BE 12-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(x6)			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(6)		MG 12-5-8	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START Time: 1:10 OVEN TEMPERATURE: 320 OF FINISH TIME: 1:40	0.00 0.00				6X		M-L 12/05/08	

MI 21134

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				6	0		DR 12-5-8
Quality Control									
165	Identify as per dwg & Stock Location	0.00							
165									
Packaging	Memo	0.00				6x			SP 12-5-10
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							12/5/10
Quality Control									

MLJ 12/05/10

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Picklist Print

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Page 1

Work Order ID: 83947

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Parent Item: D3270-041

D3270-041

Parent Item Name: Fuel Scupper Assembly

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3270-1		Manufactured	No			100	Each	61.0000	1	6			
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D3270-1

Mounting Base

**

A 12-5-2

Location

Loc Qty

Loc Code

WA022

61

24076

43

72362

18

M6061T6T0.375W.035

Purchased

No

100

f

163.2082

0.6666

4.210105

M6061T6T0 375W 035

6061-T6 RD Tube .375 x.035W

**

A 12-5-2

Location

Loc Qty

Loc Code

MAT014

163.2082

112652

163.2082

4.21

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

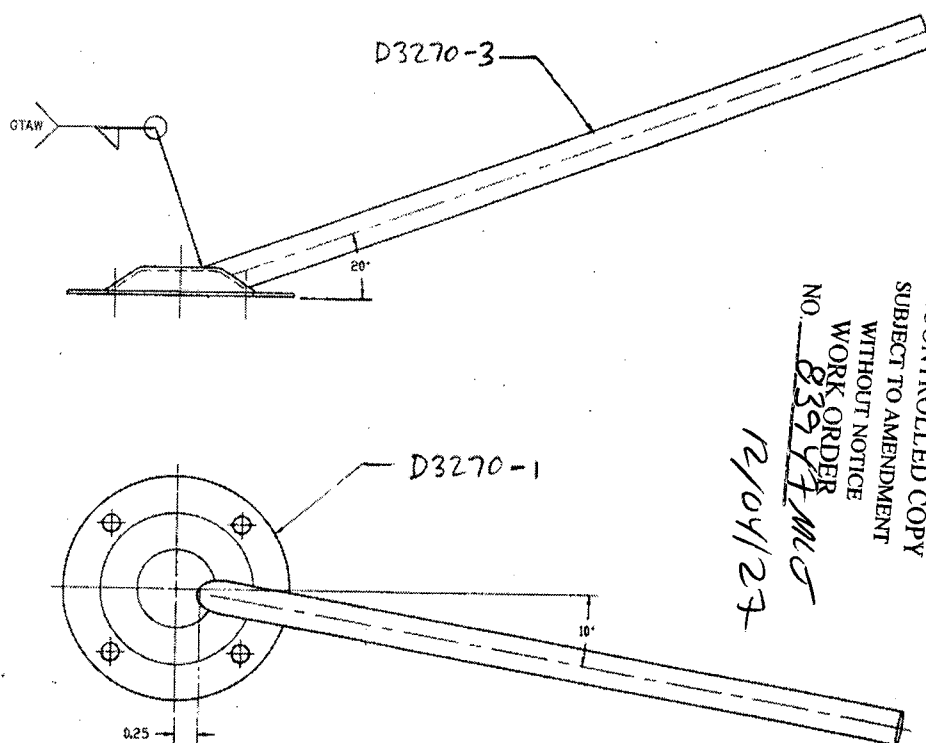
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14		TITLE FUEL SCUPPER DRAIN ASSEMBLY	SCALE NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.06.23



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83944 M/S
12/04/27

D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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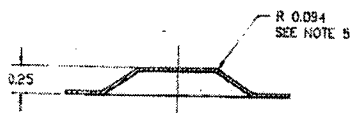
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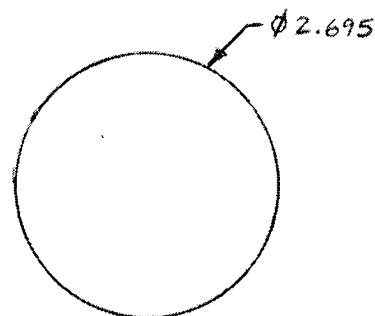
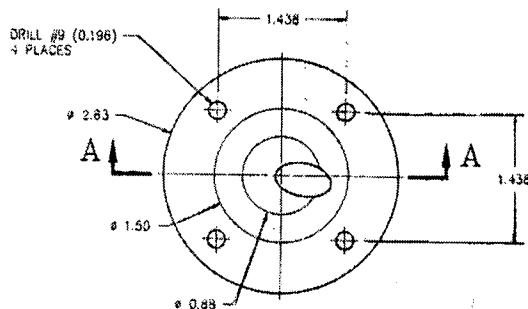


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3270 REV. B SHEET 2 OF 2
DATE	05.07.14			TITLE FUEL SCUPPER ASSEMBLY SCALE NTS
A	04.02.20			NEW ISSUE
B	05.07.14			ADD D3270-1 FLAT PATTERN

RELEASED
04.02.23 *[Signature]*



SECTION A-A



D3270-1 FLAT PATTERN

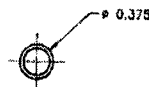


D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1



D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W.035)

03947
t6630

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